

LUSFF

Date: Tuesday, 04/07/2006 8:34:23 AM
User: Linda Lacelle

Process Sheet

Need by July 14th!

Customer:	CU-DAR001 Dart Helicopters Services		Drawing Name	: WEBBING TIDY		
Job Number	27757					
Estimate Number	11381					
P.O. Number	N/A		Part Number	: D32153		
This Issue	04/07/2006	S.O. No. : N/A	Drawing Number	: D3215 REV C		
Prsht Rev.	NC		Project Number	: N/A		
First Issue	28/06/2006	Type : LARGE FAB ASSY	Drawing Revision	: C		
Previous Run	25880		Material	: N/A		
Written By	: <u>SEE COMMENT BELOW</u>		Due Date	: 20/07/2006		
Checked & Approved By	: <u>N</u>		Qty:	50	Um:	Each
Comment	: Est. A 04.01.06 New issue KJ/RF					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M5052H32S040	5052-H32 .040 Sheet
Comment: Qty.: 0.0271 sf(s)/Unit Total : 1.3545 sf(s) 5052-H32 .040 Sheet Material: 5052-H32 (QQ-A-250/8) 0.040" thick (M5052H32S.040) Identify for D3215-3A Batch: M15982		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK		
5.0	BRAKE NC	NC BRAKE
Comment: NC BRAKE Form D3215-3A as per Dwg D3215		

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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 27757

Part Number: D32153

Job Number:



Seq. #: Machine Or Operation:

Description:

6.0 QC5

INSPECT WORK TO CURRENT STEP



Job 07-10

Comment: INSPECT WORK TO CURRENT STEP

7.0 LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

Identify as D3215-3

Grind flush

CPL 06-07-12

8.0 QC5/9

WELD INSPECTION



Comment: WELD INSPECTION

WD 06-07-12

(48)

9.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

a.m 06-07-13

(48)

10.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

a.m 06-07-14

(48)

11.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

c2 06/07/14

(48)

12.0 PACKAGING 1

PACKAGING RESOURCE #1



ST

1D+stack

c2 06/07/14

(48)

Comment: PACKAGING RESOURCE #1

13.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

H 06-07-17

Job Completion



U 06-07-15

Date: Wednesday, 6/28/2006 4:18:42 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: WEBBING TIDY	
Job Number	: 27757		Part Number	: D32153	
Estimate Number	: 11381		Drawing Number	: D3215 REV C	
P.O. Number	:		Project Number	: N/A	
This Issue	: 6/28/2006 S.O. No. :		Drawing Revision	: C	
Prsh Rev.	: NC		Material	:	
First Issue	: / / Type : LARGE FAB ASSY		Due Date	: 7/20/2006	
Previous Run	: 25880		Qty:	50 Um: Each	
Written By	:				
Checked & Approved By	:				
Comment	: Est. A04.01.06 New issue KJ/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M5052H32S040	5052-H32 .040 Sheet	
2.0	SHEAR		
	Comment: SHEAR Cut blank: 2.562" x 0.880", grain along 2.562"		
3.0	HAAS VERTICAL MACHINING #1	HAAS CNC VERTICAL MACHINING #1 Day Rev: C Prog Rev: C	
	Comment: HAAS CNC VERTICAL MACHINING #1 Machine D3215-3A as per Folio FA376 and dimensions Use Stack of 10 Identify as D3215-3A		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
	Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
	Comment: LARGE FABRICATION RESOURCE 1 Deburr		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
06/07/10	Q	2 piece were out of tolerance Twice.		Scrap destroy	SB 06/07/10	✓ 06.07.10		✓ 06.07.10

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:18:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 27757

Part Number: D32153

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC8 SECOND CHECK



J 06.07.07 (50)

Comment: SECOND CHECK

7.0 M5052H32S040 5052-H32 .040 Sheet



C Comment: Qty.: 0.0271 sf(s)/Unit Total : 1.3845 sf(s)

5052-H32 .040 Sheet

Material: 5052-H32 (QQ-A-250/8) 0.040" thick
(M5052H32S.040)

Identify as D3215-3B

Batch:

M15982

FF 06.07.07

50

8.0 SHEAR



SHEAR



Comment: SHEAR

Cut blank: 2.130" x 0.530"
Deburr D3215-3A/3B

06.07.07

FF 06.07.07

50

9.0 BRAKE NC



NC BRAKE



Comment: NC BRAKE

Form D3215-3A as per Dwg D3215

SD 06/07/00

48

10.0 QC5



INSPECT WORK TO CURRENT STEP



J 06.07.10

PTD

Comment: INSPECT WORK TO CURRENT STEP

11.0 LARGE FAB 1



LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld D3215-3 by joining D3215-3A and D3215-3B as per Dwg D3215 and QSI 004

Identify as D3215-3

Grind flush

CPL

06.07.12

W

12.0 QC5/9



WELD INSPECTION



Comment: WELD INSPECTION

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:18:42 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEBBING TIDY

Job Number: 27757

Part Number: D32153

Job Number:



Seq. #:	Machine Or Operation:	Description :
13.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
<p>Comment: HAND FINISHING RESOURCE #1 Chemical Conversion Coat as per QSI 005 4.1</p>		
14.0	POWDER COATING	POWDER COATING
<p>Comment: POWDER COATING Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3</p>		
15.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
<p>Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION</p>		
16.0	PACKAGING 1	PACKAGING RESOURCE #1
<p>Comment: PACKAGING RESOURCE #1</p>		
17.0	DC	DOCUMENT CONTROL
<p>Comment: DOCUMENT CONTROL Inspection Level 21</p>		

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD	Work Order:	27751
Description: Webbing Tidy	Part Number:	D3215-3
Inspection Dwg: D3215 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

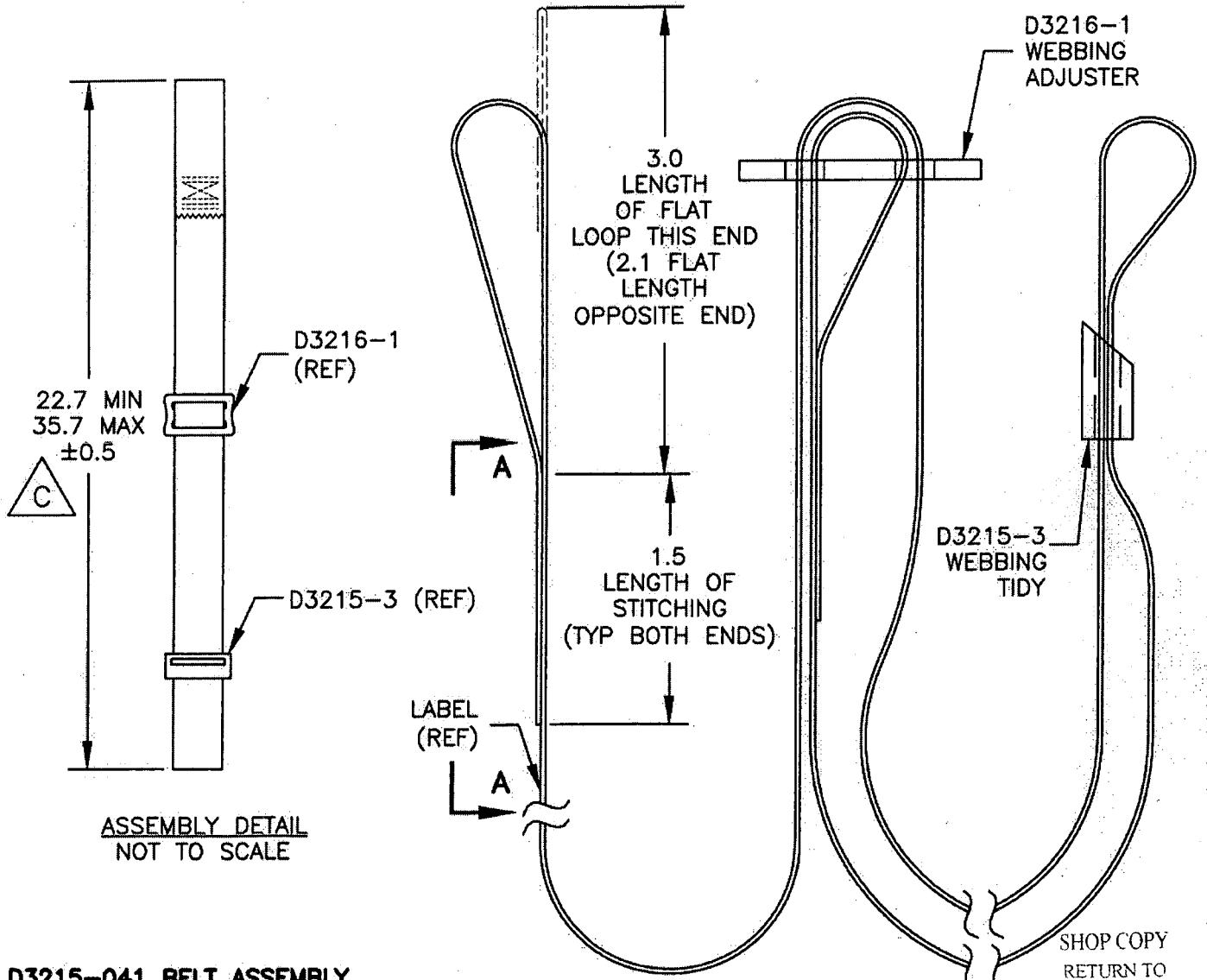
See attached

Measured by:	Audited by:	Prototype Approval:	N/A
Date:	Date:	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.02.10	New Issue	KJ/RF	
B	06.03.15	Dwg Rev update	KJ/JLM	Spoff

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DRAFT

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D3215	SHEET 1 OF 3
DATE	TITLE	SCALE	
04.03.05	BELT ASSEMBLY	NTS	
A	03.09.19	NEW ISSUE	
B	04.01.12	AS MANUFACTURED; ADD TOLERANCE	
C	04.03.05	REDUCE LENGTH; CLARIFY STITCHING	

RELEASED
04.03.08**D3215-041 BELT ASSEMBLY**

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472
(2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED DRAFT COPY
TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN) SUBJECT TO AMENDMENT
THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
LABEL = TYVEK
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

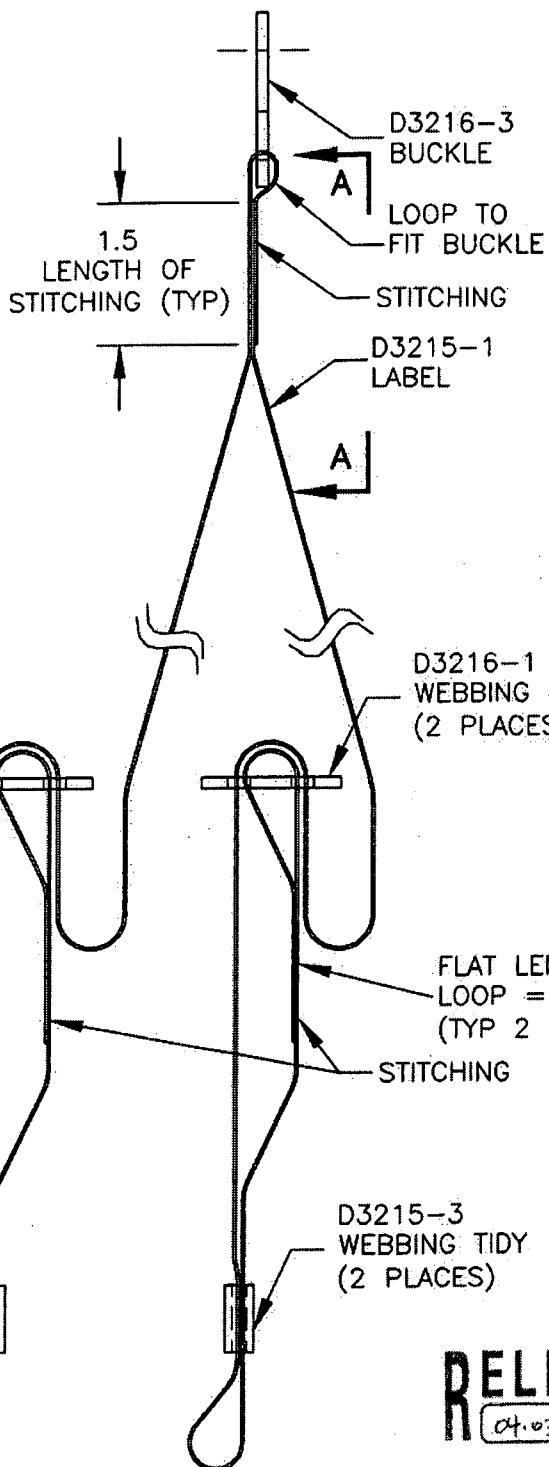
NO 27757

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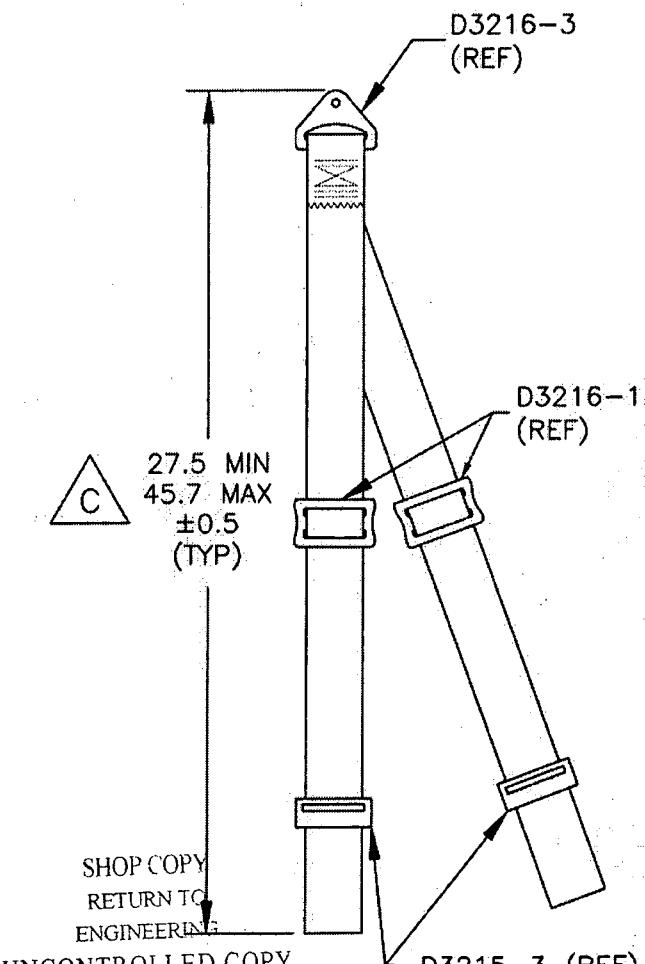
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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO. D3215
DATE		REV. C SHEET 2 OF 3 TITLE BELT ASSEMBLY SCALE NTS

**D3215-043 BELT ASSEMBLY**

- 1) MATERIAL: WEBBING = LAGRAN CANADA INC. 26472 (2" WIDE x 0.060" THICK BLACK POLYESTER WEBBING, CERTIFIED TO FAR 29.853A3, TENSILE STRENGTH 5700 lb MIN) THREAD = VT 295 TYPE II CLASS A SIZE 3, BLACK NYLON THREAD
- 2) ALL DIMENSIONS ARE IN INCHES
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

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WITHOUT NOTICE

WORK ORDER

ASSEMBLY DETAIL

NO. 21751 NOT TO SCALE

RELEASED
04.03.08

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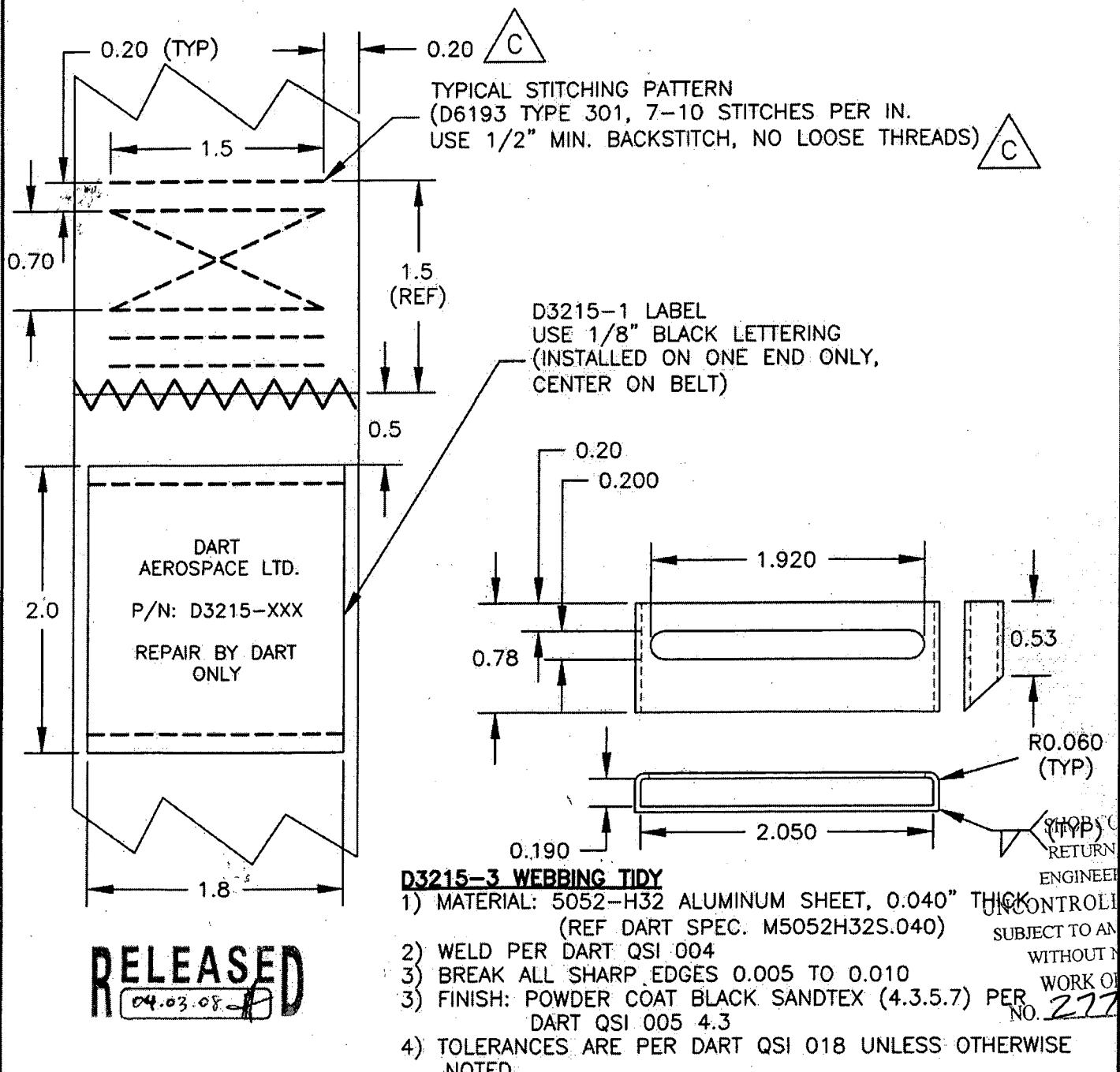
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DESIGN	DP	DRAWN BY	DP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	✓	APPROVED	✓	DRAWING NO. D3215 REV. C SHEET 3 OF 3
DATE	04.03.05			TITLE HARNESS ASSEMBLY SCALE 1:1

VIEW A-A

XXX = 041 FOR D3215-041
 XXX = 043 FOR D3215-043



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DART AEROSPACE LTD	Work Order:	27757
Description:	Part Number:	D32153
Inspection Dwg: , Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article X Prototype

Measured by:	<u>MM</u>
Date:	06 07 08

Prototype Approval:	—
Date:	—

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	